



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4703-043
Job Sheet 166552



Part No: D4703-043

Job Qty: 2 ea

Part Name: Lock Pin Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/25/17

Created By: Marie Lajeunesse

Type: Stock ✓

Description:

Note: DWG REV B SHEETS 2,4, IPP REV:A NEW ISSUE 12-09-12 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea		10/24/17	0.00	0.00	Start Up Machining		5.6 17/10/17
100	Bandsaw	2 pcs		10/24/17	0.00	0.00	Bandsaw1		3.0 17/10/17
110	CNC Vertical Machining	2 pcs		10/24/17	0.61	1.06	HAAS 1		mark 17/11/01
120	QC	2 pcs		10/24/17	0.00	0.00	QC2		mark 17/11/01
130	QC	2 pcs		10/24/17	0.00	0.00	QC8		FK. 17-11-02.
132	Outsource	2 pcs		10/24/17	0.00	0.00	Outsource4		
134	Packaging	2 pcs		10/24/17	0.00	0.00	Packaging2		DAS
136	QC	2 pcs		10/24/17	0.00	0.00	QC3		38
137	Small Fab	2 pcs		10/25/17	0.00	0.17	Small Fab		SS. 9-89 DAS
138	QC	2 pcs		10/25/17	0.00	0.00	QC5		38
140	Packaging	2 pcs		10/25/17	0.00	0.00	Packaging3	still sl	9-89
150	QC21-SA	2 Ea		10/25/17	0.00	0.00	QC21		17/10/17

Part Op 100 - -Cut blanks to 2.6"

Descriptions: 110 - 1-Machine as per folio FB d4703-1 FOLIO REV: AA DWG REV: B 2-Deburr

137 - Assemble as per DWG sheet 2

ATG P/O: 28349 e 17/11/17
132- Black anodize per Mil-8625F Type 3 class 2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X01.000	0	18	0	0
137-Small Fab	MS21209-F415 FM137951.84	2	29	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S013872



Lock Pin Base

PART NO: D4703-043
Revision:
Operation: Outsource
Change No:

Mfg Date: 11/25/17
Job No: 166552

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
S004006



Lock Pin Base

PART NO: D4703-043
Revision:
Operation: Start up Operation
Quantity: 2
Change No:

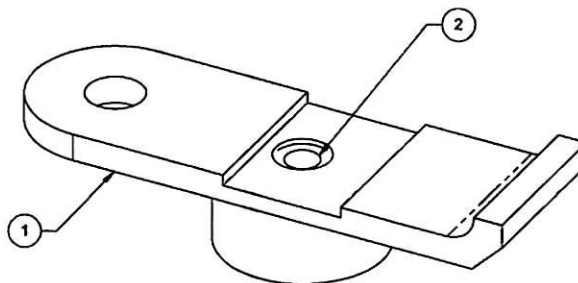
Mfg Date: 10/31/17
Job No: 166552

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ITEM	QTY. -043	P/N	DESCRIPTION
	X	D4703-043	LOCK PIN BASE
1	1	D4703-1	LOCK PIN BASE
2	1	MS21209F4-15	HELICOIL, LOCKING



D4703-043 LOCK PIN BASE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

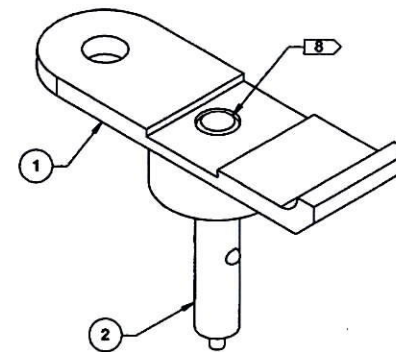
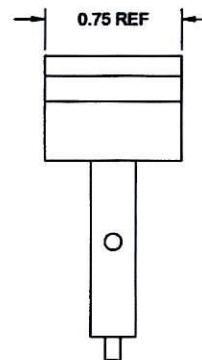
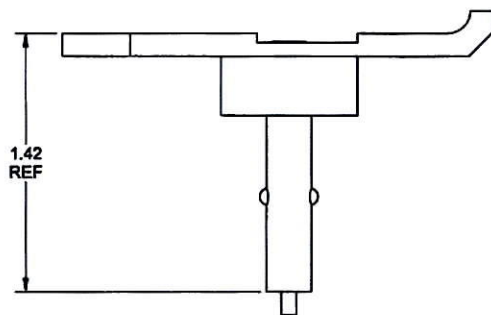
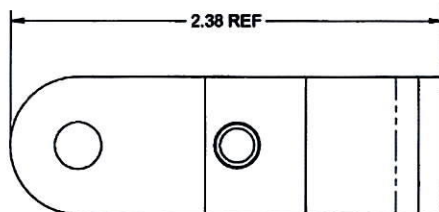
RELEASED

2017 MAY 24 *q*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4703-041	LOCK PIN ASSY
1	1	D4703-043	LOCK PIN BASE
2	1	D4705-1	QUICK RELEASE PIN



D4703-041 LOCK PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.05 lbs
- 8) APPLY LOCTITE 262 TO D4703-043 THREADS PRIOR TO FASTENING D4705-1

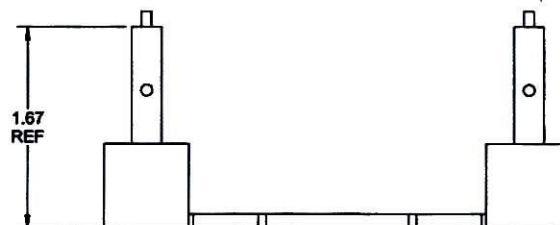
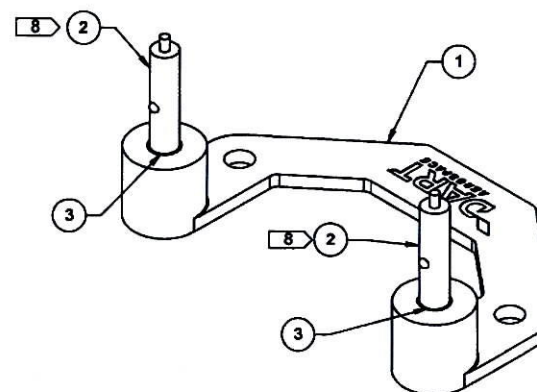
RELEASED

2017 MAY 24
2017-571

APPROVED

B	ADDED D4703-045 AND D4703-3	VS	17.01.03
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	-045		
	X	D4703-045	LOCK PIN ASSY
1	1	D4703-3	LOCK PIN BASE
2	2	D4705-1	QUICK RELEASE PIN
3	2	MS21209F4-15	HELICOIL, LOCKING



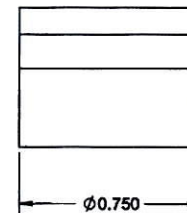
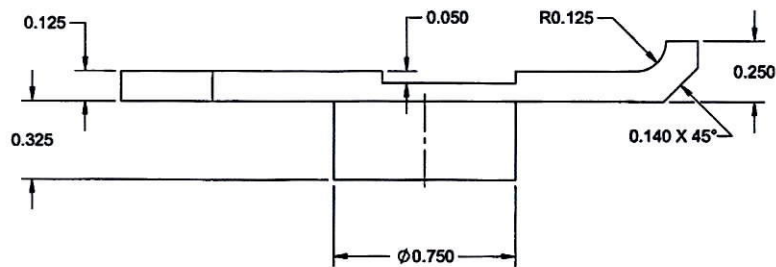
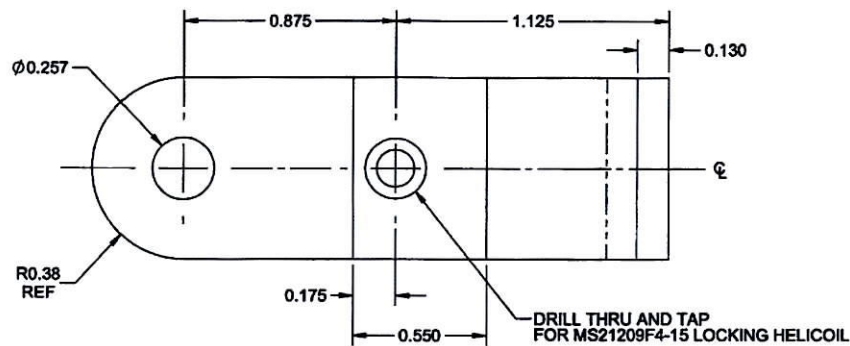
D4703-045 LOCK PIN ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
 - 7) WEIGHT: 0.12 lbs
 - 8) APPY LOCTITE 262 TO MS21209F4-15 THREADS PRIOR TO FASTENING D4705-1

RELEASED
2017 MAY 24

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
DATE	17.01.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4703-1 LOCK PIN BASE

NOTES:

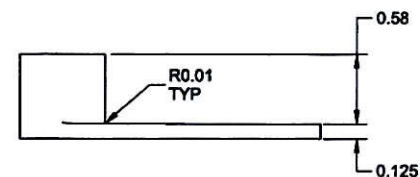
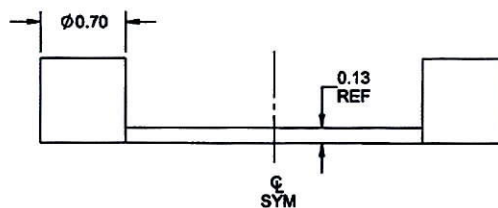
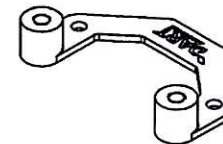
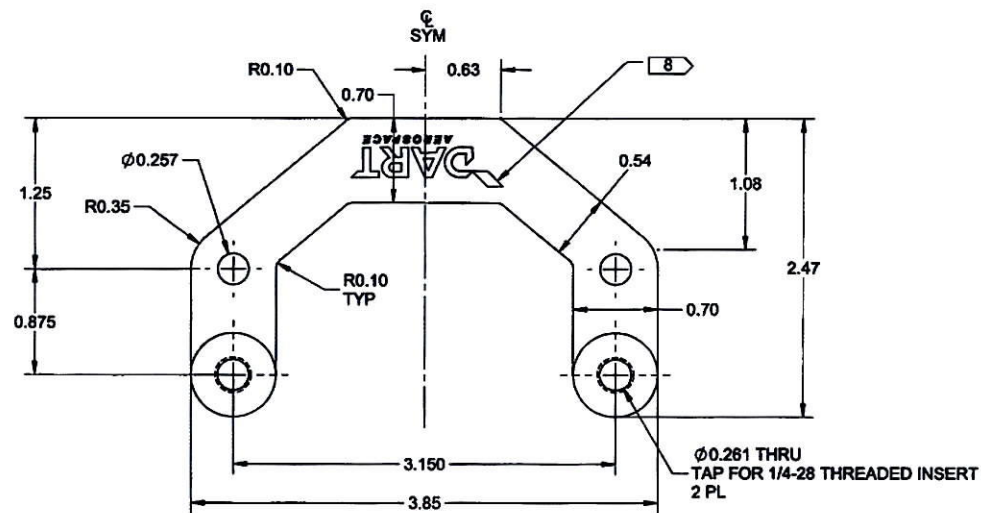
- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED

2017 MAY 24 *qp*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
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D4703-3 LOCK PIN BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP

RELEASED

2017 MAY 24 *qp*

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4703	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LOCK PIN ASSY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038349

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038349
PO Date: 11/14/17
Due Date: 11/17/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167956	649.5111	-	LH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	4 pcs	0 pcs	4 pcs	\$18.30/pcs	\$73.20
Line Item Note: RUSH!!!!												
2	167957	649.5112	-	RH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	4 pcs	0 pcs	4 pcs	\$18.30/pcs	\$73.20
Line Item Note: RUSH!!!!												
3	167199	646.9910	-	Struts Issue P/O to ATG : AS PER DWG 646.9900 HARD ANODIZE BLACK/PRIME		Firmed	11/17/17	55 pcs	0 pcs	55 pcs	\$15.40/pcs	\$847.00
4	166552	D4703-043	-	Lock Pin Base Issue P/O to ATG : As Per Dwg D4703 BLACK ANODIZE		Firmed	11/17/17	2 pcs	0 pcs	2 pcs	\$9.35/pcs	\$18.70
5	166817	D4824-1	-	Upper Cutter Mount Issue P/O : AS PER DWG D4824 HARD BLACK AMNODIZE/PRIME		Firmed	11/17/17	10 pcs	0 pcs	10 pcs	\$15.40/pcs	\$154.00
6	167390	RBEM210V4000103-3	-	Bolt -Issue P/O to ATG : AS PER DWG RBEM210V4000103 -ANODIZE COLOR CLEAR		Firmed	11/17/17	2 pcs	0 pcs	2 pcs	\$9.35/pcs	\$18.70
7	166865	649.4816	-	Doubler ISSUE P/O : AS PER DWG 649.4800 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	20 pcs	0 pcs	20 pcs	\$32.00/pcs	\$640.00
8	166658	646.3610	-			Firmed	11/17/17	10 pcs	0 pcs	10 pcs	\$8.60/pcs	\$86.00



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914174

Date: 24-Nov-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: RBE703A94-1130-01-05 Fixture Handle Clear Anodize per MIL-A-8625F, Type II, Class 1 Job: 21977	Rev: 6 PO: PO038349 Line: 11	
1 ea	Part: RBW6205G26251-3G Spacer Clear Anodize per MIL-A-8625F, Type II, Class 1 Job: 21979	Rev: 1 PO: PO038349 Line: 13	
1 ea	Part: RBW6205G25831-3G-3 Puller Assembly, Lever Clear Anodize per MIL-A-8625F, Type II, Class 1 Job: 21983	Rev: 3 PO: PO038349 Line: 17	
2 ea	Part: D4703-043 Lock Pin Base Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Job: 21970	Rev: B PO: PO038349 Line: 4	807-11-25
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 24/11/17 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M6061T6B0.750X01.000 Revision: 6061-T6 Bar .750 X 1.00														
100	Receive Ft	S003959	166552	0 ft	0	m134705	Start Up Machining	Bin	Stock	10/31/2017	.			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		1		0	0									

Plex 1/8/2018 1:16 PM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			